GENERAL INTERNATIONAL

OPERATING MAINTENANCE INSTRUCTIONS

15" SINGLE SURFACE PLANER
30-125CE M1

FEATURES

- Heavy duty enclosed stand protects motor from dust and provides a stable work station.
- Heavy duty cast iron frame provides more precision.
- Four columns design provides extra stability of the cast iron table to keep the parallelism with the head.
- An offset 5" (127 mm) dust chute to keep work area clean.
- Knife setting gauge included.
- Comes with 3 driving V-belts for more power.
- Magnetic safety switch for more security.
- Two rollers 15" built on the top of the machine provide convenient handling for consecutive cutting operations.
- Machine base has 4 lockable wheels to allow easy movement around the workshop.
- The head of the machine is equipped with anti-kickback fingers.
- The table can locked by 2 lock-knobs for more precision.
- Cast iron large extension wings.

SPECIFICATIONS

TABLE AREA WITH TABLE EXTENSION	**15" x 48 1/8" (381 x 1222 mm)**
MAXIMUM PLANING WIDTH	**15" (381 mm)**
MAXIMUM PLANING THICKNESS	**6" (152 mm)**
MINIMUM PLANING THICKNESS	**3/8" (10 mm)**
MINIMUM PLANING LENGTH	**6 1/2" (165 mm)**
MAXIMUM CUTTING DEPTH	**1/8" (3 mm)**
CUTTERHEAD DIAMETER	**2 7/8" (73 mm)**
KNIVES	**3 (DOUBLE EDGE)**
CUTTERHEAD DIAMETER	**5000 RPM**
FEEDING SPEEDS (2)	**16 & 20 FPM (4.87 & 6.1 MPM)**
MOTOR	**3 HP, 220 V, 1 Ph**
WEIGHT	**539 LBS (245 kg)**

SAFETY RULES

READ CAREFULLY BEFORE OPERATING THE MACHINE

1. Learn the machine's applications and limitations, as well as the specific potential hazards particular to this machine. Follow available safety instructions and safety rules carefully.

2. Keep working area clean and be sure adequate lighting is available.

3. Do not wear loose clothing, gloves, bracelets, necklaces, or ornaments. Wear face, eye, ear, respiratory and body protection devices, as indicated for the operation or environment.

4. Keep hands well away from cutterhead and all moving parts. Do not clear chips and sawdust away with hands. Use a brush.

5. Keep guards in place and in working order. If a guard must be removed for maintenance or cleaning make sure it is properly attached before using the tool again.

6. Do not push the cutting tool to hard. The cutting tool will perform better and be safer working at the rate for which it was designed. Feed work into a blade against the direction of rotation of the blade.

7. Whenever possible use a dust collector with shaving hood to minimize health hazards.

8. Be positive that hold-downs and anti-kickback devices are positioned properly, and that the workpiece is being fed through the cutting tool in the right direction.

9. Never leave the machine with the power on.

10. Do not use a dull, bent or cracked cutting tool.

11. Never stand on tool. Serious injury could occur if the tool is tipped or if the cutting tool is unintentionally contacted.

12. Make sure tool is properly grounded. If tool is equipped with three-prong plug, it should be plugged into a three-pole electrical receptacle. Never remove the third prong.

13. Always disconnect tool before servicing and when changing accessories such as blades and cutters.

14. Make sure that switch is in "OFF" position before plugging in cord.

15. Be sure that key and adjusting wrenches have been removed before turning power on.

16. Use only accessories designed for the machine.

17. Clamp workpiece or guide prevent injury.

18. Do not start any operation before checking that the cutters are tight to cutterhead also check if the cutters are positioned at the same level.

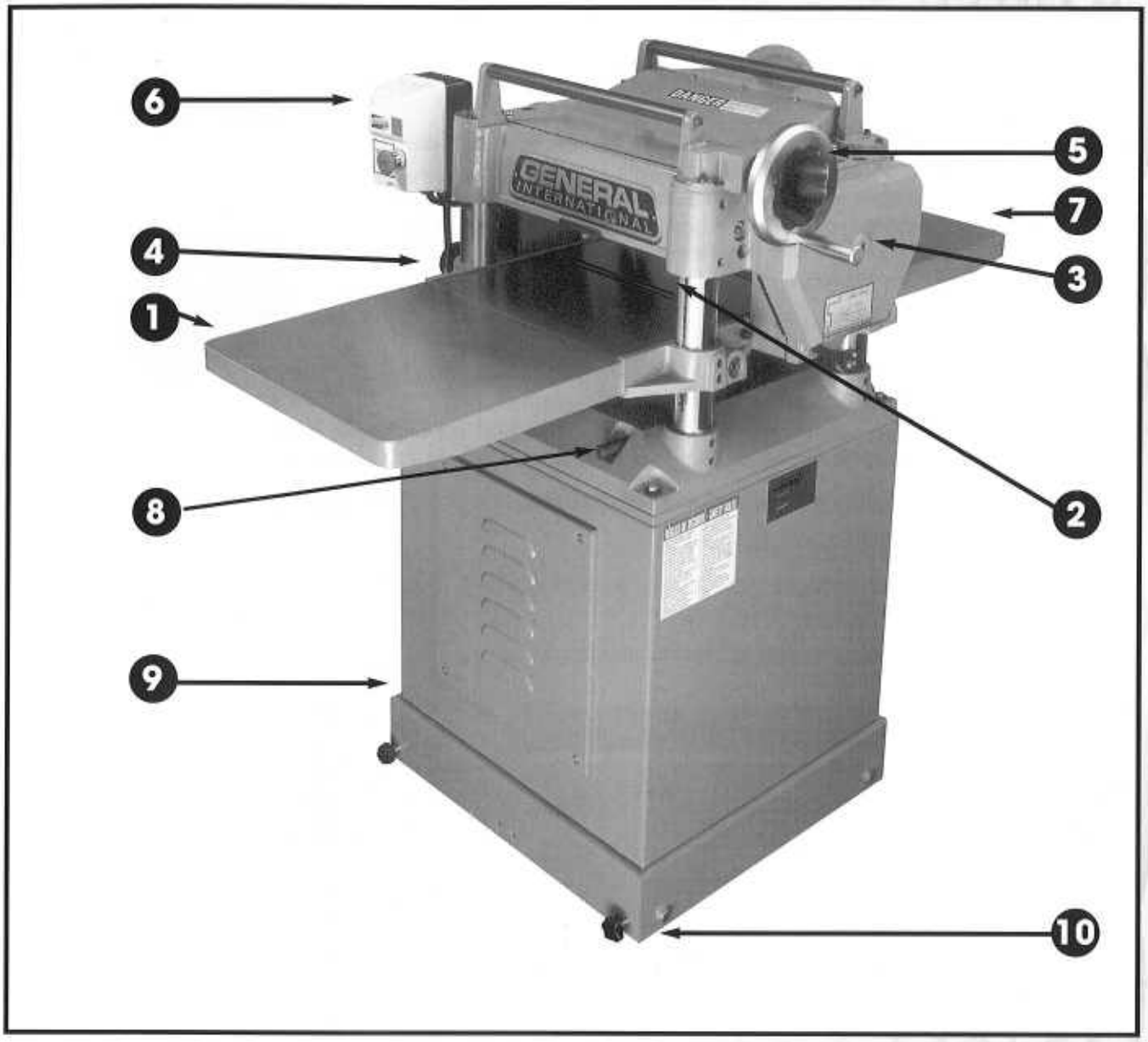
19. Use caution when placing hands near the cutterhead, knives are extremely sharp.

20. Use ONLY recommended accessories. Use of accessories NOT recommended by General International may result in a risk of injury.

21. Do not use this planer for other than it's intended use. If used for other purposes, General International disclaims any real or implied warranty and holds itself harmless for any injury, which may result from that use.

GENERAL ® INTERNATIONAL guarantee

All component parts of GENERAL INTERNATIONAL machinery are carefully inspected during all production stages and each machine is thoroughly inspected upon completion of assembly. Because of quality, GENERAL INTERNATIONAL agrees to repair or replace any genuine part or parts which, upon examination, proves to be defective in workmanship or material within a period of 24 months from date of purchase.In order to obtain warrantee, all defective parts must be returned prepaid to GENERAL INTERNATIONAL MFG. Co Ltd. Repairs made without our written authorization voids all guarantees.



1. FRONT EXTENSION TABLE
2. DEPTH SCALE
3. GEAR BOX
4. TABLE LOCK KNOB (NOT SHOW ON PICTURE)
5. ELEVATING HAND WHEEL
6. MAGNETIC SWITCH
7. REAR EXTENSION TABLE
8. LIFTER BAR
9. CABINET STAND
10. CASTOR

15" PLANER
30-125CE M1

GENERAL® INTERNATIONAL Planer are carefully tested and inspected before shipment and if properly used will give perfect results. However, a reasonable amount of care and attention is necessary to ensure perfect performance and accurate work. It is imperative that you take a few moments to familiarise yourself with these instructions, as they will no doubt save you a lot of time and trouble.

UNPACKAGE AND CLEANUP

To ensure maximum performance from your GENERAL® INTERNATIONAL 15" Planer, clean it properly; and install it accurately before use. As soon as you receive your 30-125CE M1, we recommend you follow these procedures:

1. Finish removing the contents of the shipping wooden case and compare with the contents list.
2. Report damage, if any to your local distributor.
3. Clean all rust protected surfaces with a mild solvent or kerosene. Do not use lacquer thinner; paint thinner, or gasoline. These will damage painted surfaces.
4. To prevent rust, apply a light coating of paste wax to surface.

CONTENTS LIST

ITEM # 1
(1) 3 mm Allen Wrench
(1) 4 mm Allen Wrench
(1) 5 mm Allen Wrench
(1) 6 mm Allen Wrench
ITEM # 2
(2) Knife Setting Guide
ITEM # 3
(1) 8-10 mm Open End Wrench
(1) 12-14 mm Open End Wrench
(1) 17-19 mm Open End Wrench
ITEM # 4
(4) "C" clip
ITEM # 5
(3) M5 Hex Head Screw
ITEM # 6
(3) M6 Cap Screw
ITEM # 7
(3) Spring Washer
ITEM # 8
(1) Knife Setting Guide Shaft
ITEM # 9
(1) Hand wheel
(1) Handle
(1) Direction Label
(1) Nut
(1) Washer
ITEM # 10
(2) Extension table
ITEM # 11
(1) Dust chute
ITEM # 12
(6) M8 Hex. Head Screw
(6) M8 Set Screw
ITEM # 13
(2) Knob
ITEM # 14
(3) Flat Washer
ITEM # 15
(4) 3/8" Hex. Head Screw
(4) Flat Washer
(2) " L " type metallic plate

••••••CAUTION!••••••

NEVER ATTEMPT TO CONNECT TO AN OUTLET WITH A GREATER POWER SOURCE VOLTAGE THAN REQUIRED!

••••••WARNING!••••••

ALWAYS VERIFY THAT THE MACHINE IS PROPERLY GROUNDED TO AVOID ELECTRIC SHOCK TO THE WORK OPERATOR!

ELECTRICAL REQUIREMENTS

Before connecting the machine to the power source verify that the voltage supplied corresponds as specified on the nameplate of the machine. A power source with greater voltage than needed can result in serious injury to the user as well as damage the machine. If in doubt, contact a qualified electrician before connecting to the power source.

GROUNDING

Machine must be properly grounded in order to avoid electric shock to the work operator.

Connect to a circuit breaker no greater than voltage supplied on name plate, to avoid shock or fire; replace the power cord if it gets worn out, cut or damaged in any way replace immediately.

INSTALLATION

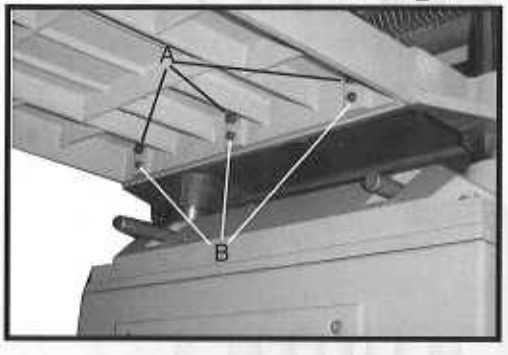
- Make sure location is a fixed solid foundation. Verify that the machine remains steady and properly balanced.
- Choose work area accordingly, avoiding obstacles that may interfere while work operations are being performed.

Fig. 1

WARNING !

DISCONNECT THE MACHINE BEFORE PERFORMING ANY ADJUSTMENTS! FAILURE TO COMPLY CAN CAUSE SERIOUS INJURIES TO THE MACHINE AND THE WORK OPERATOR!

Fig. 2



ADJUSTMENTS

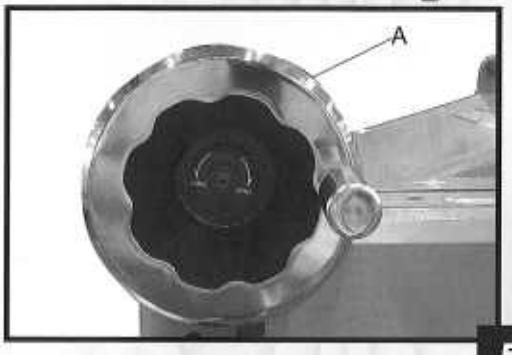
MACHINE ANCHOR

Use two "L" type metallic plate locating in front and back of the stand to fix machine on the floor. (Fig. 1)

EXTENSION TABLES (Fig. 2)

- Install set screw(B) into extension table so that they are levelled with the surface that faces the machine.
- To attach the table extension to machine use hex head bolts(A).
- Find a straight edge approximately four feet long to adjust table extension.
- Using bolts(A) and set screws(B), adjust so that when the straight edge is lying on the table extension, there is no space between the straight edge and the table.
- Tighten screw(A).
- Repeate the same procedures for the opposite of table extension.

Fig. 3



HEIGHT ADJUSTMENT (Fig. 3)

Turn handwheel (A) clockwise or counter-clockwise to adjust to the required height.

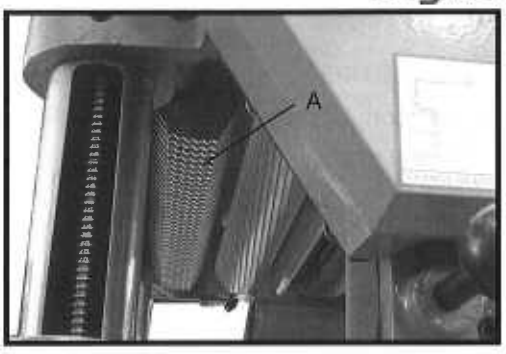
DEPTH OF CUT ADJUSTMENT (FIG. 4)

Fig. 4

- The depth of cut is controlled by raising and lowering the table as illustrated in Fig.4. The table raises and lowers on four precision steel ground columns.
- To Adjust: Loosen the two head assembly lock knob (A), and turn the elevating handwheel (B) .
- When required depth is obtained, lock the two head assembly lock knobs In order to maintain the current depth.
- A scale (C) is located on the right front column for easy reading.
- The maximum depth of cut on full width planing is 1/8". A limiter (D) is provided to limit the depth of cut. If the workpiece to be cut is less than 6", the allowable maximum depth of cut is no more than 1/4" (6 mm) in one pass.

ANTI-KICKBACK FINGERS (FIG. 5)

Fig. 5

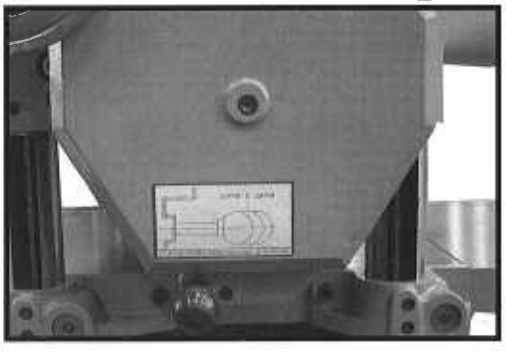


Anti-kickback fingers (A) are provided on your planer to prevent kickback. These fingers operate by gravity and it is necessary to inspect them occasionally.

In order for the anti-kickback fingers to move freely and operate correctly, you must clean off any dust, particles or residue left behind.

FEED ROLLER SPEED CONTROL (FIG. 6)

Fig. 6



The 30-125CE M1 Planer is equipped with a spiral, serrated infeed roller and rubber outfeed roller

When the feed rollers are engaged, they turn and feed the stock. The feed rollers slow automatically when the machine is under heavy load in order to gives great results under all planing conditions. The feed roller are driven by a chain and sprocket drive, which takes power directly from the cutterhead through the oil bath gearbox.

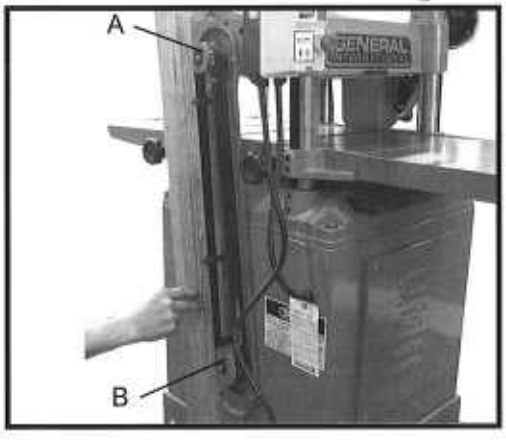
To engage: the feed rollers, pull out the lever as illustrated in (Fig.6).

To disengage: the feed rollers, push the lever back in towards machine.

To change: the feed speed, push the lever in for 20 FPM, or pull lever out for 16 FPM. Set the lever in neutral position for zero speed.

Note: speed change can only be changed when the machine is running.

Fig. 7



WARNING !

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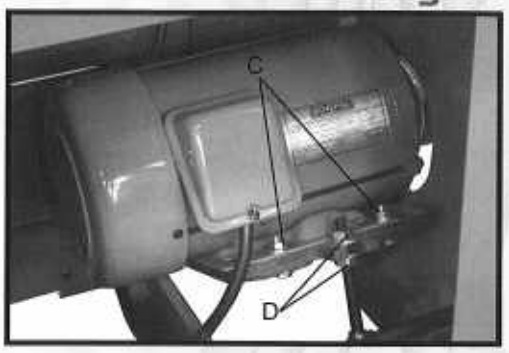
CHECKING PULLEY (FIG. 7)

To verify that motor pulley (B) is in line with the shaft pulley of (A), using the edge of a straight scale check to see if they are on-line with each other.

ADJUSTING MOTOR MOUNT (FIG. 8)

If motor pulley B and shaft pulley A, are not on-line loosen screw (C) as shown in (Fig.8), move motor to left and right until adjusted to proper position and tighten the screw again.

Fig. 8



ADJUSTING BELT TENSION (FIG. 8)

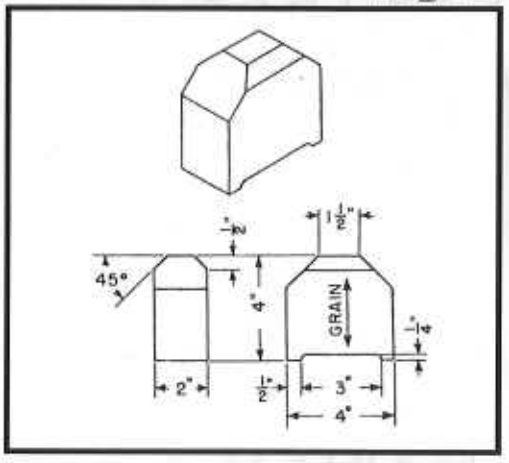
Use the two nuts (D) to adjust the belt tension (Fig.8) When achieved proper position of adjustment tighten bolts to hold in place.

ADJUSTMENTS (FIG. 9)

Planer has been factory adjusted, and requires no further modifications; however considering the handling and transit movement from the warehouse to the destination, minor adjustments may be needed before starting work operations.

To adjust: you will need a straight edge, a feeler gauge and a home made gauge block made of hardwood. The gauge block can be made by following the dimension illustrated in (Fig.9)

Fig. 9



KNIVES (FIG. 10)

TO REPLACE: USE THE FOLLOWING METHODS:

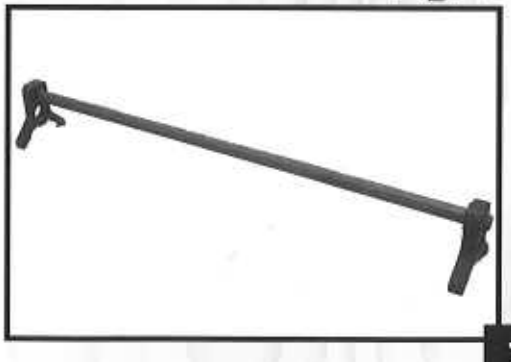
1. Disconnect the machine from the power source.
2. Remove the four screws, as illustrated in (Fig.10); remove the top cover.
3. Loosen the two knobs and remove pulley cover.

Fig. 10

TO ADJUST: USE THE FOLLOWING METHODS:

1. Use knife gauge and verify all three knives for proper setting as illustrated in (Fig.11)
2. A properly placed gauge should slightly touch the bottom of the center protrusion of the gauge.
3. If adjustment is required; slightly loosen the knife locking bars of all three knives by turning the fifteen knife locking screws into the knife locking bars. Screws should just be loose enough to relieve stress in the cutterhead without disturbing the knives setting.
4. Use the knife gauge to adjust the knife that needs to be adjusted; loosen the five locking screws by turning them into the knife locking bar.
5. As the knife locking bar becomes loose, the springs under the knife will raise until it contacts with the center portion of the gauge. Close up the knife locking bar by lightly backing out the five screws against the slot. Temporarily tighten the knife into slot in order to hold in position.
6. If additional knives must be reset repeat steps 4 & 5.
7. After all three knives are set, tighten the five screws against the slot starting with the end screw and then the center screws. Make sure knife is securely tightened to cutterhead before proceeding with the next two knives.

Fig. II



To remove: use the following steps.

1. Loosen the knife locking bar by turning the five knife locking screws; remove the knife locking bar, springs located under the knives.
2. Remove the remaining knives in the same manner.
3. Clean the knife slots, knife bars, screws and springs. Replace screws if threads appear worn or stripped.
4. Inspect the cutting edges of knives for nicks or warped edges. Grind the knives using a stone or sharpen if required. Always maintain a cutting angle of 35 degrees as illustrated in (Fig.12).
5. Insert springs, knives and knife locking bars into all three slots on the cutterhead. Back out the locking screw just enough to hold all three knives in the cutterhead.
6. Place the knife gauge (A) over one of the knives, as illustrated in (Fig.12).
7. Hold down the knife gauge and loosen all five locking screws (D) turn them into bar (C) until the cutting edge of the knife (F) comes in contact with the protrusion (B) of the gauge. Close the knife locking bar(C) by slightly backing out the five screws (D) against the slot.

Note: Slightly tighten in order to hold in position, in order to insert the remaining knives.

8. Replace and reset the other two knives in the same manner.
9. Once all three knives are set up tighten the five screws against the slot starting with the end screw and then the center screws. Verify that the knives are securely held in the cutterhead, and tighten the remaining screws.

Fig. 12

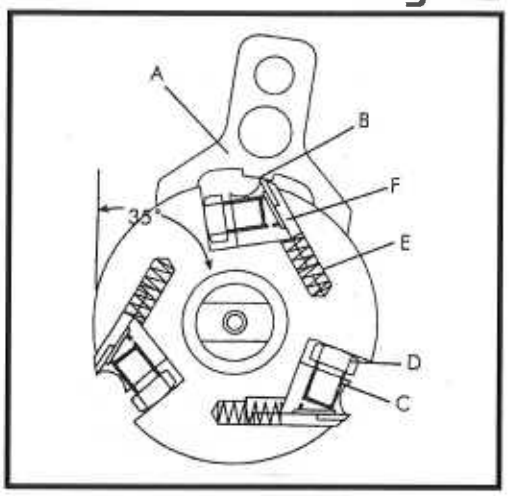
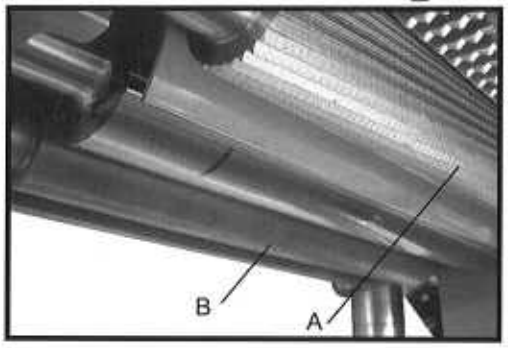


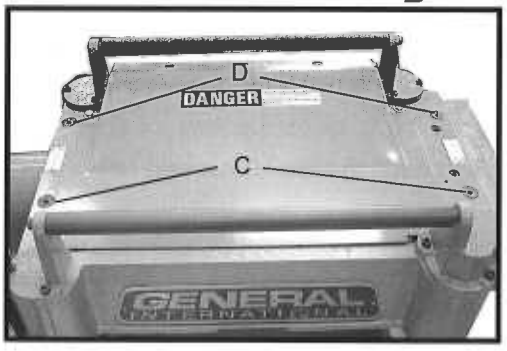
Fig. 13



ADJUSTING FEED ROLLER SPRING TENSION (FIG. 13-14)

The infeed roller (A) and outfeed roller(B) are the parts that feed the stock while it is being planed. The feed rollers (A) and (B) are under spring tension and this tension must be sufficient in order to feed stock smoothly and evenly through the planer without slipping. The tension should not be too tight; this can cause damages to the board. Equal tension should be on both ends of each roller.

Fig. 14



TO ADJUST INFEED ROLLER

- Turn screw (C) clockwise to increase tension and counte-clockwise to decrease tension. Adjust equally at both ends of the rollers (Fig. 14).

TO ADJUST OUTFEED ROLLER

- Turn screw (D) clockwise to increase tension and counter-clock wise to decrease tension. Adjust equally at both ends of the rollers (Fig. 14).

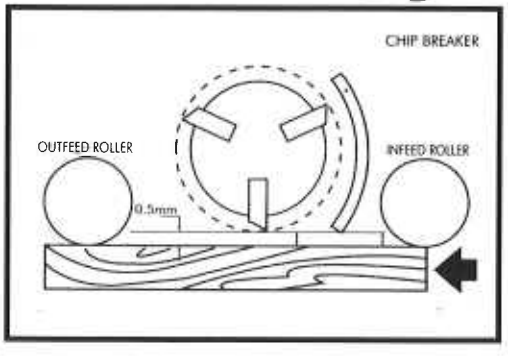
ADJUSTING HEIGHT OF OUTFEED ROLLER (FIG. 15)

The outfeed roller is factory adjusted at 0.5 mm below the cutting circle.

Follow theses methods in order to adjust:

1. Disconnect the machine from the power source.
2. Verify that the knives are properly adjusted as indicated under "Knives" page 7.
3. Place the gauge block on the table directly underneath the cutterhead. Use a 0.5 mm feeler gauge, place on top of the gauge block, raise or lower the head until the knife slightly touches the feeler gauge when knife is at the lowest point. Do not move the table any further until the out feed roller is adjusted.

Fig. 15



4. Move the gauge block under the end of the outfeed roller (Fig15). The bottom of the outfeed roller should slightly touch the top of the gauge block. If adjustment to the outfeed roller is necessary, loosen the locknut and turn screw until feed roller slightly touches the gauge block. Re-tighten locknut in order to hold in position.
5. Verify and adjust opposite end of outfeed roller the same way.

ADJUSTING CHIPBREAKER (FIG. 16-17-18)

The chipbreaker is located on top of the planer and extends down around the front of the cutterhead. The chipbreaker raises as stock is fed through and "breaks or curls" the chips. The bottom of the chipbreaker must be parallel to the knives and set 0.5 mm below the cutting circle.

To verify and adjust chipbreaker, follow these procedures:

1. Disconnect the machine from the power source.
2. Verify that the knives are adjusted properly as previously explained under "Knives" page 7.
3. Place the gauge block (A) on the table directly underneath the cutterhead as illustrated in (Fig.16). using a 0.5 mm feeler gauge (B), place on top of the gauge block, raise or lower the head until the knife (C) slightly touches the feeler gauge when the knife is at its lowest point. Do not move the table any further until the chipbreaker is checked and adjusted as required.
4. Move the gauge block (A) underneath the chipbreaker (D) as illustrated in (Fig.17). the bottom of the chip breaker should slightly touch the top of the gauge block. Check the opposite end of the chipbreaker the same way.
5. If any adjustments are required, loosen nuts (F) as illustrated in (Fig.18). Turn screws (E) until the bottom of the chipbreaker slightly touches the gauge block. Re-tighten nuts (F) in order to hold in position.

Fig. 16

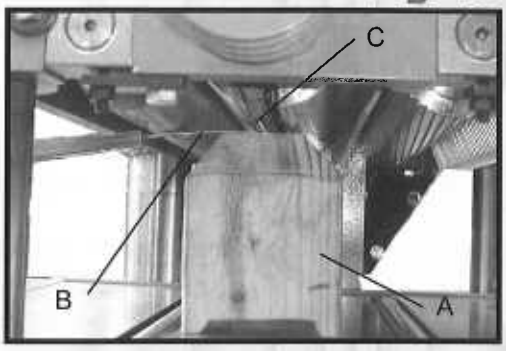


Fig. 17

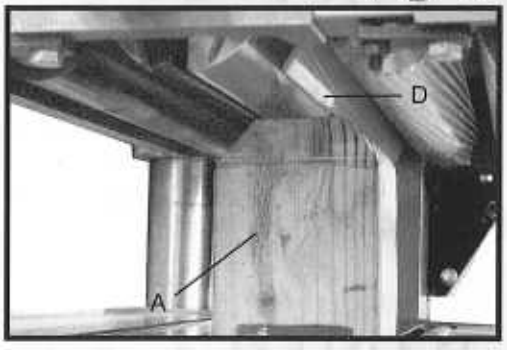
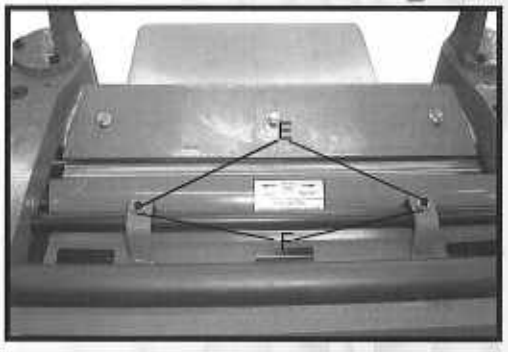


Fig. 18



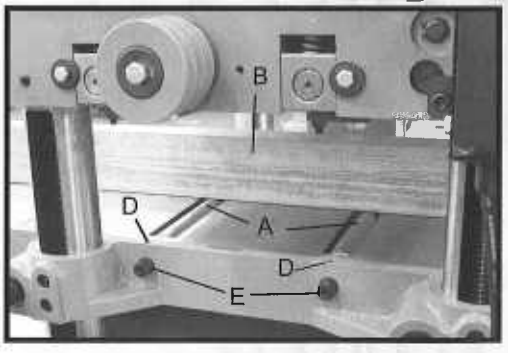
ADJUSTING TABLE ROLLERS (FIG. 19)

Your planer is equipped with two table rollers (A) (Fig.19). These rollers will help in feeding stock by reducing friction, and turn as the stock is fed through the planer. It is not possible to give exact dimensions on the proper height setting of the table rollers because each type of wood behaves differently. As a general rule, when planing rough stock the table rollers should be set High and when planing smooth stock the table rollers should be set Low. The suggested table roller height is at least 0.15 mm over the table surface.

The table rollers on the planer are set for average planing and are parallel to the table surface. If higher or lower adjustments are required, follow these procedures:

1. Disconnect the machine from the power source.
2. Place a straight edge (B) across both rollers as illustrated in (Fig.19). Loosen set screw (D) turn the two eccentric shafts (E) in order to raise or lower the table rollers, tighten set screw (D) as illustrated. Table rollers must also be adjusted on the opposite end of the table in the same way, note that table rollers must always be set parallel to the table.

Fig. 19



ADJUSTING CUTTERHEAD PARALLEL TO TABLE (FIG. 20-21-22)

The cutterhead has been pre-set parallel to the table at the factory, therefore no further adjustments are required.

If your machine is planing a taper; verify to see if knives are properly set in the cutterhead. Due to transport handling verify that the table is parallel to the cutterhead.

If adjustments are required follow these procedures:

1. Disconnect the machine from the power source.
2. Place the gauge block on table directly under cutterhead as illustrated. Rise the table until cutterhead slightly touches the gauge block.
3. Move gauge block to opposite end of table, as illustrated in (Fig. 20).
4. If cutterhead is not parallel, tilt planer on its side as illustrated in (Fig.21). Remove bolt (C) and loosen bolt (D); this will allow you to move the idler sprocket assembly far enough to release tension on the chain. Remove chain from sprocket on the end that needs to be adjusted.
5. Turn sprocket (F) by hand as illustrated in (Fig.22), adjust the first corner with the remaining three.

Note: This adjustment is very sensitiv e and it should not be neces - sar y to tur n the sproc ket mor e than one or two teeth.

6. Turning sprocket clockwise will decrease the distance between the table and cutterhead. Counter-clockwise will increase the distance.

Fig. 20

Fig. 21

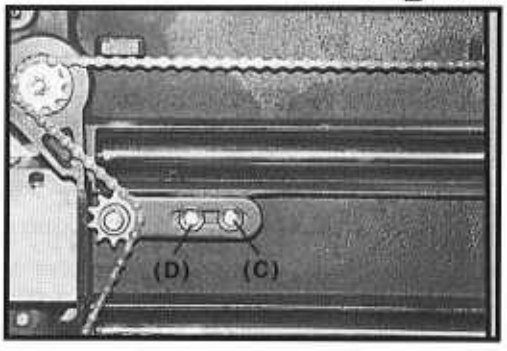
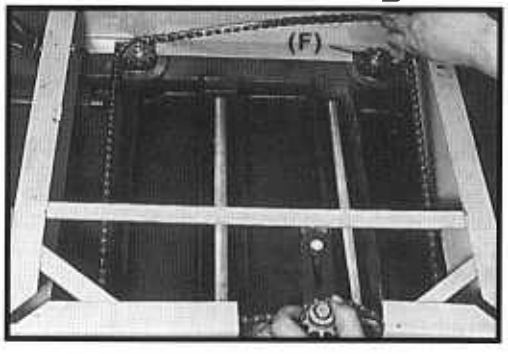


Fig. 22



LUBRICATION (FIG. 23)

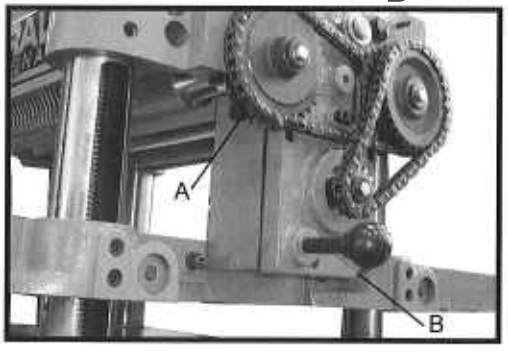
When lubrication needs to be changed:

1. Loosen the nut B on the out feed hole.
2. Clean out old lubrication and let it drain.
3. Tighten nut B.
4. Replace clean lubricant by hole A.

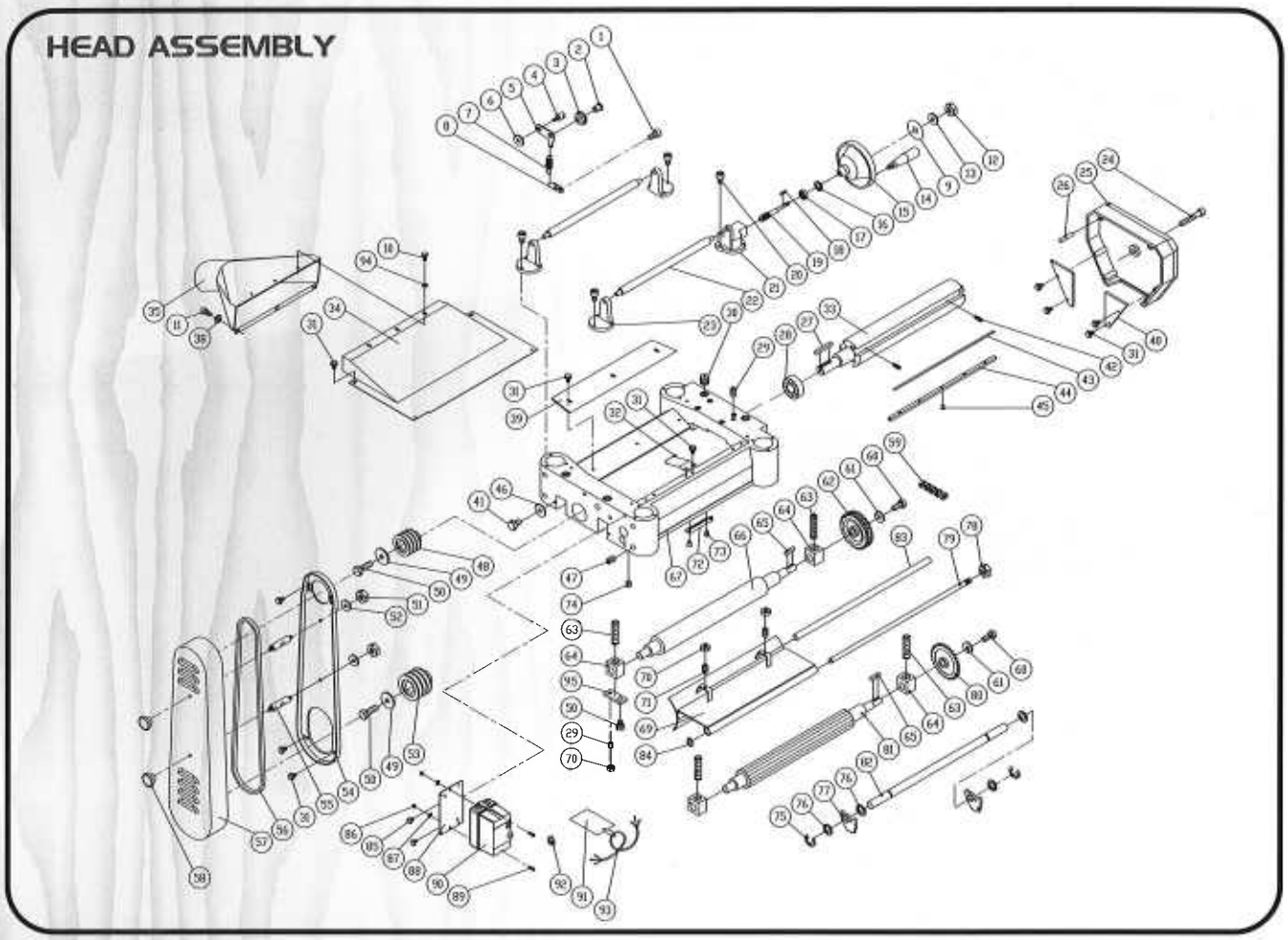
PERIODIC MAINTENANCE

1. Close fitting parts, such as the lock-bars and the planer cutterhead slots should be cleaned with a brush, remove any particle clinging to the equipment and slightly dampen with oil.
2. Remove any accumulation from the feed rollers and tables with a non-flammable solvent.
3. The gear box oil should be changed once a year.
4. The four table raising screws should be lubricated as required using a common grease.

Fig. 23



HEAD ASSEMBLY



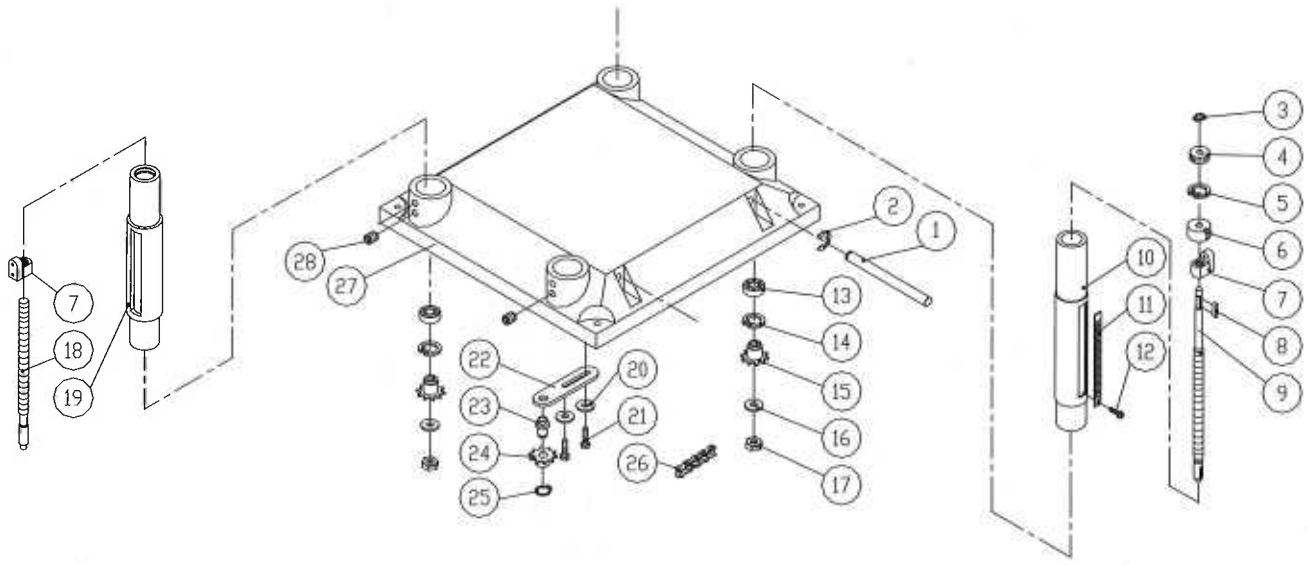
PARTS LIST 30-125
HEAD ASSEMBLY

CODE	PART NO.	DESCRIPTION	SPECIFICATION	QTY
01	30125-01	BOLT SOC. HEAD	M6 X 1.0P X 12	1
02	30125-02	SHAFT		1
03	30125-03	IDLE PULLEY		1
04	30125-04	SHAFT		1
05	30125-05	BRACKET		1
06	30125-06	WASHER	8.2 X 22 X 3	1
07	30125-07	SPRING	1.2	1
08	30125-08	HANGER		1
09	30125-09	LABEL DIRECTION		1
10	30125-10	HEX. HEAD SCREW	M5X0.8PX12	3
11	30125-11	CAP SCREW	M6X1.09X12	3
12	30125-12	HEX.NUT	M10X1.25P	1
13	30125-13	WASHER	3/8"X20X1.5	1
14	30125-14	HANDLE		1
15	30125-15	HAND WHEEL		1
16	30125-16	RETAINING RING	RTW-30	1
17	30125-17	BEARING	#6200Z(A)	1
18	30125-18	KEY	4X4X10	1
19	30125-19	WORM GEAR		1
20	30125-20	BOLT SOC. HEAD	M6X1.0PX20	12
21	30125-21	BOX WORM GEAR		1
22	30125-22	ROLLER		2
23	30125-23	ROLLER BRACKET		3
24	30125-24	BOLT SOC. HEAD	M8X1.25PX50	1
25	30125-25	COVER		1
26	30125-26	SPRING PIN	6X20	2
27	30125-27	KEY	8X8X35	1
28	30125-28	BEARING	#6205ZZ	1
29	30125-29	SET SCREW	M6X1.0PX16	5

PARTS LIST 30-125
HEAD ASSEMBLY

CODE	PART NO.	DESCRIPTION	SPECIFICATION	QTY
30	30125-30	SCREW	M22X1.5PX20	4
31	30125-31	BOLT PAN HEAD	M6X1.0PX12	17
32	30125-32	BRACKET		3
33	30125-33	CUTTERHEAD		1
34	30125-34	DUST COVER		1
35	30125-35	COLLECTOR HOOD		1
38	30125-38	SPRING WASHER	6.1X10.2X4	3
39	30125-39	CHIP DEFLECTOR PLATE		1
40	30125-40	PLATE		2
41	30125-41	BOLT HEX. HD	M6X1.0PX12	8
42	30125-42	SPRING	0.6	6
43	30125-43	See 30-130		3
44	30125-44	CUTTERHEAD GIB		3
45	30125-45	BOLT GIB	M8X1.25PX10	15
46	30125-46	WASHER	5/16"X23X2	4
47	30125-47	SET SCREW	M10X1.5PX12	8
48	30125-48	DRIVEN PULLEY		1
49	30125-49	WASHER	8X30X3	2
50	30125-50	BOLT HEX. HD	M8X1.25PX20	6
51	30125-51	HEX.NUT	5/16"X18NC	2
52	30125-52	WASHER	5/16"X16X1.5	2
53	30125-53	MOTOR PULLEY	ø 84	1
54	30125-54	PULLEY GUARD		1
55	30125-55	STUD		2
56	30125-56	BELT	M58	3
57	30125-57	PULLEY COVER		1
58	30125-58	NUT		2
59	30125-59	CHAIN	#06BX63	1
60	30125-60	BOLT HEX. HD	M6X1.0PX16	2
61	30125-61	WASHER	6.2X20X3	2
62	30125-62	SPROCKET	31t	1
63	30125-63	SPRING		4
64	30125-64	RETAINING BRACKET		4
65	30125-65	KEY	5X5X22	2
66	30125-66	OUTFEED ROLLER		1
67	30125-67	HEAD CASTING		1
68	30125-68	RIVET	2.5X5	2
69	30125-69	CHIP BREAKER		1
70	30125-70	NUT HEX.HD	M6X1.0P	6
71	30125-71	SET SCREW	M6X1.0PX16	2
72	30125-72	DEPTH LIMITER		1
73	30125-73	PHILIPS SCREW	M5X0.8PX12	2
74	30125-74	SET SCREW	M8X1.25PX12	1
75	30125-75	E-RING	ETW-15	2
76	30125-76	SPACER		40
77	30125-77	ANTI-KICKBACK PAWL		39
78	30125-78	NUT.HEX	M12X1.75P	1
79	30125-79	SHAFT		1
80	30125-80	SPROCKET	31t	1
81	30125-81	INFEED ROLLER		1
82	30125-82	SHAFT		1
83	30125-83	CHIP DEFLECTOR SHAFT		1
84	30125-84	RETAINING RING	STW12	1
85	30125-85	HEX. SCREW	M6X1.0PX12	2
86	30125-86	NUT HEX.HD	3/16"-24NC	2
87	30125-87	WASHER	BW-5	2
88	30125-88	SWITCH BOARD		1
89	30125-89	SCREW PAN HD.	3/16"-24NCX5/8"	2
90	30125-90	SWITCH (CSA)		1
91	30125-91	LABEL		1
92	30125-92A	STRAIN RELIEF	1/2"	2
93	30125-93A	POWER SUPPLY CORD	14A/32X2MX1R2Y	1
94	30125-94A	FLAT WASHER		3
	30125-HB	HARDWARE BAG		1
	30125-HB1	KNIFE SETTING GAUGE ASS'Y		1
95	30125-95A	PLATE		4

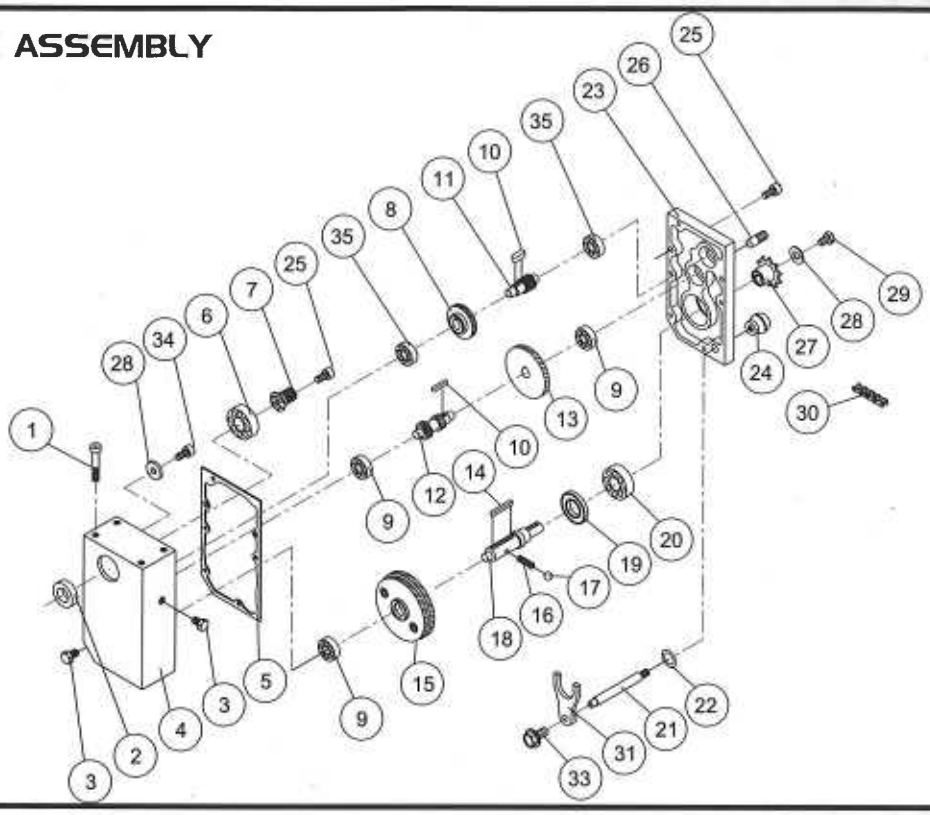
BASE ASSEMBLY



PARTS LIST 30-125
BASE ASSEMBLY

CODE	PART NO.	DESCRIPTION	SPECIFICATION	QTY
01	30125-92	BAR		4
02	30125-93	E-RING	ETW12	4
03	30125-94	RETAINING RING	STW10	1
04	30125-95	GEAR		1
05	30125-96	INTERNAL RING	RTW38	1
06	30125-97	BUSHING		1
07	30125-98	LEAD NUT		4
08	30125-99	KEY	4X4X10	1
09	30125-100	CRANK LEAD SCREW		1
10	30125-101	COLUMN		1
11	30125-102	SCALE		1
12	30125-103	SCREW PAN HD.	M3X0.5PX6	1
13	30125-104	BEARING	6202Z(A)	4
14	30125-105	INTERNAL RING	RTW35	4
15	30125-106	SPROCKET		4
16	30125-107	WASHER	3/8"X20X1.5	4
17	30125-108	NUT HEX	M10X1.25P	4
18	30125-109	LEAD SCREW		3
19	30125-110	CRANK CASE COLUMN		3
20	30125-111	WASHER	8.2X22X3	2
21	30125-112	BOLT HEX. HD.	M8X1.25PX25	2
22	30125-113	BRACKET TENSION		1
23	30125-114	SHAFT		1
24	30125-115	SPROCKET		1
25	30125-116	RETAINING RING	STW15	1
26	30125-117	CHAIN	#410X134	1
27	30125-118	BASE		1
28	30125-119	SET SCREW	M10X1.5PX12	8

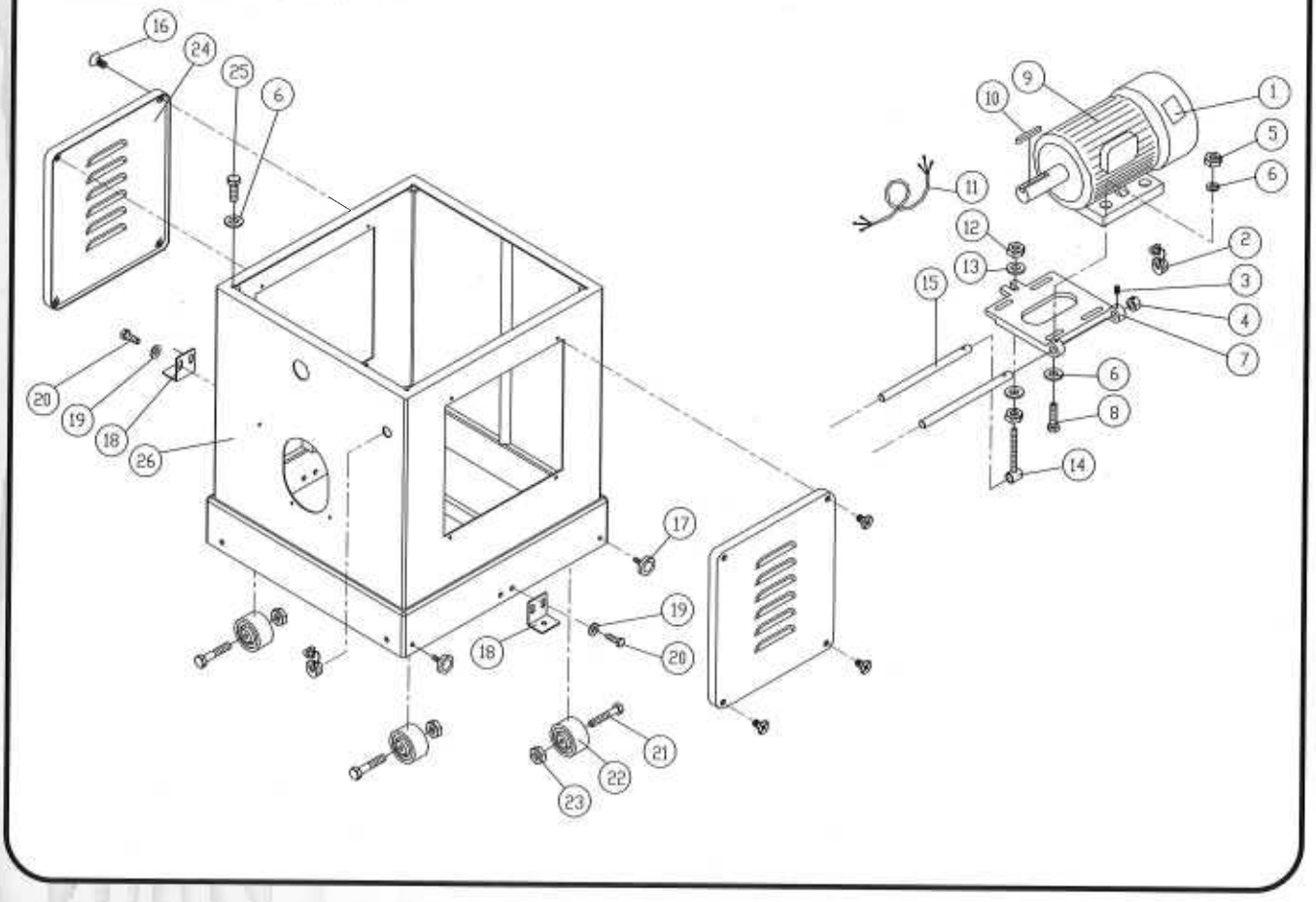
GEAR BOX ASSEMBLY



PARTS LIST 30-125
GEAR BOX ASSEMBLY

CODE	PART NO.	DESCRIPTION	SPECIFICATION	QTY
01	30125-120	BOLT SOC.HD	M8X1.25PX50	4
02	30125-121	OIL SEAL	TC28X40X8	1
03	30125-122	PLUG NPT	PT1/4"-19	2
04	30125-123	GEAR BOX		1
05	30125-124	GASKET		1
06	30125-125	BEARING	#6204ZZ	1
07	30125-126	HELICAL GEAR		1
08	30125-127	GEAR	47t	1
09	30125-128	BEARING	#6201(A)	3
10	30125-129	KEY	5X5X10	2
11	30125-130	SINGLE GEARED SHAFT	18t	1
12	30125-131	DOUBLE GEARED SHAFT	18.22	1
13	30125-132	GEAR	71t	1
14	30125-133	KEY	6X6X40	1
15	30125-134	GEAR ASSEMBLY		1
16	30125-135	SPRING	ø 0.6	1
17	30125-136	STEEL BALL	ø 6	1
18	30125-137	GEAR SHAFT		1
19	30125-138	OIL SEAL	SC25X47X6	1
20	30125-139	BEARING	#6204Z(A)	1
21	30125-140	HANDLE CLUTCH		1
22	30125-141	O-RING	P12	1
23	30125-142	COVER GEAR BOX		1
24	30125-143	KNOB	AE32X3/8"-16NC	1
25	30125-144	HEX. HD. BOLT	M6X1.0PX25	6
26	30125-145	PIN	8X20	2
27	30125-146	SPROCKET	12t	1
28	30125-147	WASHER	6.2X20X3	2
29	30125-148	HEX. HD. BOLT	M6X1.0PX16	1
30	30125-149	CHAIN	#06BX47	1
31	30125-150	CLUTCH		1
32	30125-151	WASHER	1/4"X13X0.8	1
33	30125-152	HEX. HD. BOLT	M6X1.0PX12	1
34	30125-153	SOC.HD. BOLT	M6X1.0PX12	1
35	30125-154	BEARING	#6201	2

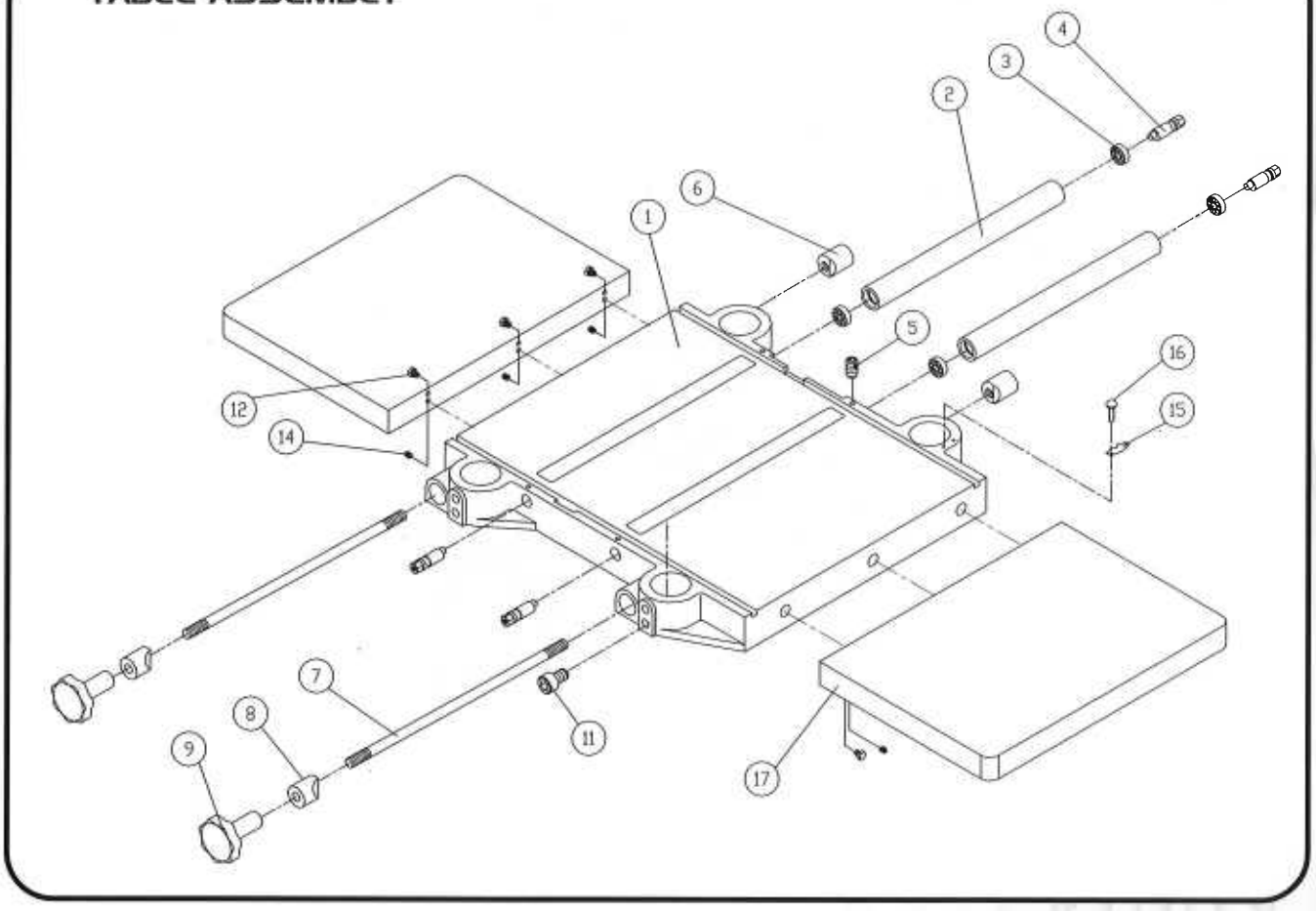
CABINET ASSEMBLY



PARTS LIST 30-125
CABINET ASSEMBLY

CODE	PART NO.	DESCRIPTION	SPECIFICATION	QTY
01	30125-155	MOTOR LABEL	(CSA)	1
02	30125-156	STRAIN RELIEF	SB8R-3	2
03	30125-157	SET SCREW	M6X1.0PX12	4
04	30125-158	SPACER		1
05	30125-159	HEX.NUT	M8X1.25P	4
06	30125-160	WASHER	5/16"X23X2	12
07	30125-161	MOTOR PLATE		1
08	30125-162	HEX. HD. BOLT	M8X1.25PX30	4
09	30125-163	MOTOR	3HP-115V/230 (CSA)	1
10	30125-164	KEY	5X5X30	1
11	30125-165	MOTOR CORD	14A/3CX1.4mX1R2Y1R2T	1
12	30125-166	HEX. NUT	M10X1.25P	2
13	30125-167	WASHER	1/2"X28X3	2
14	30125-168	TENSION BOLT ASSEMBLY		1
	30125-169	TENSION BOLT	M10X1.25PX100	1
	30125-170	RETAINER	16.5X21.7X25	1
15	30125-171	PIVOT BAR		2
16	30125-172	FLAT HD. SCREW	M6X1.0X12	8
17	30125-173	LOCK WHEEL	38X5/16"-18NCX3/4	2
18	30125-174	ANGLE SET STIFFENING PLATE		2
19	30125-175	WASHER	3/8"X20X15	4
20	30125-176	HEX. HD. BOLT	3/8"-16NCX3/8"	4
21	30125-177	HEX. HD. BOLT	3/8"-16NCX2-1/2"	4
22	30125-178	WHEEL		4
23	30125-179	LOCKING NUT	3/8"-16NC	4
24	30125-180	DOOR		2
25	30125-181	HEX. HD. BOLT	M8X1.25PX40	4
26	30125-182	CABINET		1

TABLE ASSEMBLY



PARTS LIST 30-125
TABLE ASSEMBLY

CODE	PART NO.	DESCRIPTION	SPECIFICATION	QTY
01	30125-183	TABLE		1
02	30125-184	TABLE ROLLER		2
03	30125-185	BEARING		4
04	30125-186	ECCENTRIC ADJUSTER		4
05	30125-187	SET SCREW	M6X1.0PX12	4
06	30125-188	NUT LOCK	M12X1.75P	2
07	30125-189	SHAFT THREADED		2
08	30125-190	BUSHING LOCK		2
09	30125-191	KNOB	M12X1.75P	2
11	30125-199	SOC.HD. BOLT	M6X1.0PX20	8
12	30125-200	HEX. HD. BOLT	M8X1.25PX20	6
14	30125-202	SET SCREW	M8X1.25PX12	6
15	30125-203	INDICATOR		1
16	30125-204	RIVET	2X5	2
17	30125-205	EXTENSION TABLE		2